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D350-589-011
Job Sheet 192270



008979

Part No: D350-589-011

Job Qty: 2 pcs

Part Name: Side Door Latch Modification



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 3/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG INN-D350-589 REV E, DSI9760-013 IPP F 02.08.29 Removed D2587 Plug KJ ALL AT CHANGE 002

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Packaging 1 - Pick Kit	2 pcs		3/26/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S168094

Part: D350-589-011

Job No: 192270

Serial No/Batch: S168094

Revision:

Inspector:

Exp Date:

Instructions:

TC STC SH92-41 Issue 8 of 8 FAA STC SH1012NE 02/05/21, AUSTRIA

APR 01 2019

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					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
110 QC 4	2 pcs	3/26/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS 46 9-89 APR 01 2019
					QC 4 - 46	
120 Packaging 3-1 - Stock - B4B	2 pcs	3/26/19	0.00 0.00		Packaging 3 - 1 - B4B	DAS 46 9-89 APR 01 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
125 DC - 1 - B4B	2 pcs	3/26/19	0.00 0.00		DC - 1 - B4B	DAS 21 3-25 APR 01 2019
					DC - 2 - B4B	
130 QC 21 - FG	2 pcs	3/26/19	0.00 0.00		QC 21 - FG - 21	DAS 21 3-25 APR 01 2019
					QC 21 - FG - 70	
					QC 21 - SA - 53	
Part Op 105 - Pick Kit Descriptions: 110 - QC4- 100% Inspect kits for completeness 120 - Identify as per dwg & Stock Location: _____ 125 - (Document Control) 130 - QC21- Final Inspection - Work Order Release						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2237	Striker Plate	6 pcs (3 ea)	105-Packaging 1 - Pick Kit	51253841
D2583	Latch Bracket	6 pcs (3 ea)	105-Packaging 1 - Pick Kit	5128525
D2585	Latch Clamp	6 pcs (3 ea)	105-Packaging 1 - Pick Kit	5127828
D2586	Door Latch	6 pcs (3 ea)	105-Packaging 1 - Pick Kit	5134198
D2587	Door Plug	2 pcs (1 ea)	105-Packaging 1 - Pick Kit	503835241 5128520x1
D2589	Keys, Key Chain	2 pcs (1 ea)	105-Packaging 1 - Pick Kit	5132942
MS20470AD4-5	Rivet, Universal Head	12 Ea (6 ea)	105-Packaging 1 - Pick Kit	5134218
MS21042L3	Nut	6 Ea (3 ea)	105-Packaging 1 - Pick Kit	5157462
MS27039-1-15	Screw	6 Ea (3 ea)	105-Packaging 1 - Pick Kit	5112435
NAS1149D0363J	Washer	6 Ea (3 ea)	105-Packaging 1 - Pick Kit	5152662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Packaging 1 - Pick Kit	D2237	6	22	0
	D2583	6	21	0
	D2585	6	22	0
	D2586	6	21	0
	D2587	2	13	0
	D2589	2	157	0
	MS20470AD4-5	12	1,844	0
	MS21042L3	6	3,511	0
	MS27039-1-15	6	254	0
	NAS1149D0363J	6	1,803	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Revision: E

Date: 02.02.22

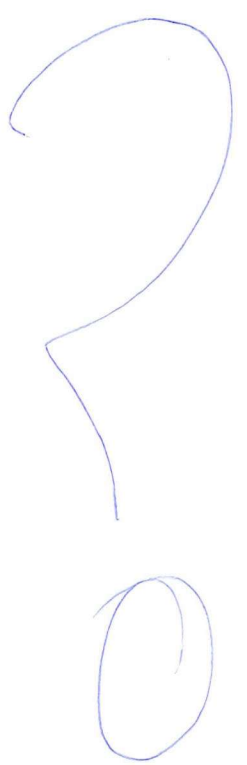
3.0 MAINTENANCE

Maintain D5275-041 Latch Assy per the applicable Instructions for Continued Airworthiness (ICA) for the D2586 Latch.

4.0 WEIGHT AND BALANCE

This change has negligible effect on Weight and Balance.

5.0 PARTS LIST



QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9760-011	WEATHERPROOF LATCH KIT
	X	DSI 9760-013	WEATHERPROOF LATCH KIT
2	3	D5275-041	DOOR LATCH ASSY
2	3	MS27039-1-17	SCREW
2	3	MS27039-1-25	SCREW
2	3	NAS1149D0363J	WASHER
2	3	MS21042L3	NUT

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	RF	DRAWING NO.
MFG. APPR.	N/A	DSI 9760
APPROVED	HS	TITLE
DE APPR.	DS	WEATHERPROOF LATCH
DATE	16.10.04	SCALE
		NTS

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